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D3913-041
Job Sheet 182733



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/30/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Large Fab-5		18-09-2018
100	Large Fab	1 pcs	9/21/18	9/21/18	0.00	10.00	Large Fab 1		18-09-2018
110	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC9		18-09-2018
120	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		18-09-2018
125	HandFinish	1 pcs	9/21/18	9/21/18	0.00	0.29	HandFinish2		18-09-2018
130	Powdercoat	1 pcs	9/21/18	9/21/18	0.00	0.93	Powdercoat2		18-09-2018
135	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging1		18-09-2018
140	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC3		18-09-2018
150	HandFinish	1 pcs	9/21/18	9/21/18	0.00	0.50	HandFinish4		18-09-2018
160	QC	1 pcs	9/21/18	9/21/18	0.00	0.00	QC5		18-09-2018
170	Packaging	1 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3-2		18-09-2018
180	QC21-SA	1 Ea	9/21/18	9/21/18	0.00	0.00	QC21		18-09-2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M83893 START: 10:30 O.V.T. 3:35 FINISH: 10:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5096603
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5087627
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	508106941
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5105281
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5110912
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5099924
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5101818

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

S097017
 S089207
 S106776
 S106778
 S089950
 S093687
 S089298-1
 F86435
 S0760071
 S078252
 S103666-1
 S072820

Job Allocations

005583

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	86	0
	D3913-1	1	8	0
	D3913-15	1	13	0
	D3913-3	1	9	0
	D3913-7	2	6	0
	D3913-9	1	13	0
	D3916-041	2	12	0
	D3916-5	3	21	0
	D4016-1	3	12	0
	D4017-7	3	31	0
	D4017-9	2	10	0
	D4020-11	2	11	0
	D4021-1	3	28	0
	D4034-041	1	8	0
	D4034-043	1	7	0
	D4672-1	2	26	0
	M304EX0.75-16F	33	1,607	0
150-HandFinish	AN3-10A	6	319	0
	D2931	2	966	0
	D4021-5	2	30	0
	MS20600-AD4W3	2	169	0
	MS21042L3	6	3,516	0
	NAS1149F0332P	12	1,693	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____ Step _____

Description Work Or

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐ Pressure/Forced
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

OTHER :

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

Master Unit 005357
Job No 182733
Part: D3913-041
Job No: 182733
Serial No/Batch: S111150
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 08/10/18

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